

Date: Monday, 14/01/2008 2:40:50 PM
 User: Linda Lacelle

quell

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKID INSTALLATION KIT
 Job Number : 36766
 Estimate Number : 12519
 P.O. Number : Part Number : D205634015
 This Issue : 14/01/2008 S.O. No. : Drawing Number : IIN D205-634 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : LANDING GEAR Drawing Revision : D
 Previous Run : 36765 Material :
 Written By : Due Date : 31/01/2008 Qty: 1 Um: Each
 Checked & Approved By : *W*
 Comment : Est Rev:A New Issue 00-04-04 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 08.01.22

Comment: Photocopy bluefile & type labels per PPP205-634-015 CHG 004

08/01/27

2.0 36766A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY 36766A

W

3.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 D205-634-011 Saddle Kit

35014

8/1/27

4.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/29

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-015

Location:

PPP Rev:

E

8/1/29

50

(A)

6.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/30

Job Completion



2008/1/30

W

B36766A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: JD Date: 08/01/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/01/2008 2:41:12 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
 Job Number : 36766A
 Estimate Number : 12520
 P.O. Number :
 This Issue : 14/01/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D205634045
 Drawing Number : D2580 REV D
 Project Number : N/A
 First Issue : / / Type : LANDING GEAR Drawing Revision : D
 Material :
 Previous Run : 36765A Due Date : 31/01/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:C Revised Steps 06-09-06 JLM
 Est Rev:D Added SS Wearplates & Gaskets 07-07-09 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG002

2.0

D25001190

Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B34729 2008/1/30
B34722 H 8-1-14

3.0

D2596

205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B36671

H 8-1-14

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

H / SL
 8-1-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 14/01/2008 2:41:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36766A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Add extra holes to web prior to bonding, per DEO 9183

9-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting
Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M105469

Sikaflex expire date: 8-1-30

Start Time: 4:30 Date: 8-1-14

Fin Time: 7:30 Date: 8-1-16

pl / SL
8-1-14

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL / JD 8-1-16

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

G.M. 08.01.17 ①

2-Drill extra fwd hole as per DEO 9183 using
drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using
drill jig DT8462

4-Drill pilot holes for aft cap using DT8215, ***DO NOT OPEN TO FINISH SIZE***

5-Drill extra aft holes as per DEO 9183 using
drill jig DT8463 locating from aft cap hole and aft saddle hole.

SL
8-1-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 14/01/2008 2:41:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36766A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08/01/17

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2576-3

Step

B33464

BE 08/01/17

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

24

D2579

Spacers

B36326

BE 08/01/17

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 08/01/17

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M106390

BE 08/01/17

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M106390

BE 08/01/17

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

*****DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384" Ø AS PER DEO 9183)****

7-Open aft cap holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

SL 8-1-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/01/2008 2:41:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36766A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-21 (1)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

↓ 0861/21 (20)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BR 08-01-24

(4)

14.0

POWDER COATING

POWDER COATING



M106316



(1X)

Comment: POWDER COATING

Powder Coat ****GREEN****Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M-L 08/01/24

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/01/25 (P)

16.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B35920

M-L

17.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M100188

M-L

18.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch:

M104374

M-L 08/01/28

(1X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 14/01/2008 2:41:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36766A

Part Number: D205634045

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

19.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)
washer
batch M106552

M. L.

20.0	ALS71032130	Insert
------	-------------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)
Insert
Batch: M105729

ALS41032130 min 2008/1/30

M. L.

21.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)
BOLT
Batch: M106785 (9X)

M106883 (41X)

(41X)

22.0	D356613	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B32744

M. L.

23.0	D35665	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B36113

M. L.

24.0	D35661	GASKET
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
GASKET
Batch: B36112

M. L.

25.0	D356413	WEARSHOE
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B33867

M. L. 08/01/28

(1X)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/01/2008 2:41:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36766A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B34805

M-L

27.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B36023

M-L

28.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B36338

M-L

29.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

O-Ring

Batch:

B27168

M-L

30.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Plug

Batch:

B35919

M-L

31.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date:

M105487
08/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

(IX)

M-L 08/01/2009

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/01/30

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/01/2008 2:41:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36766A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

M 106407

08/01

M-1

08/01/29

(18)

5-Wing Walk as per Dwg D2580 and QSI 00544

Batch:

M 106332

32.0

QC5

INSPECT WORK TO CURRENT STEP



08/01/07

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045

Location:

PPP Rev:

PPP 36766

08/01/29

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/30

Job Completion



08/01/30

(1)

W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

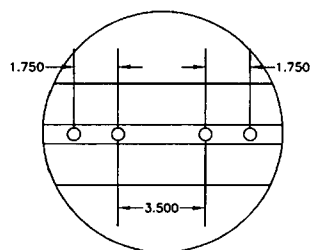
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

WLB
36766A

Copyright © 1996 by DART AEROSPACE LTD

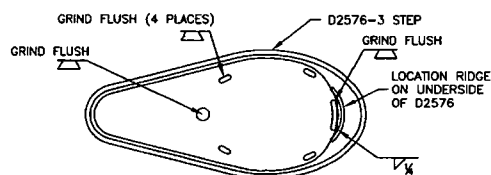
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DETAIL A
SCALE 5:24

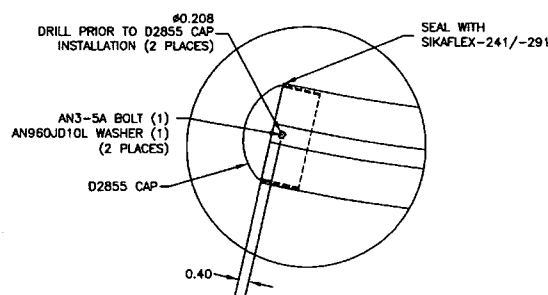


RELEASED
07 de 28

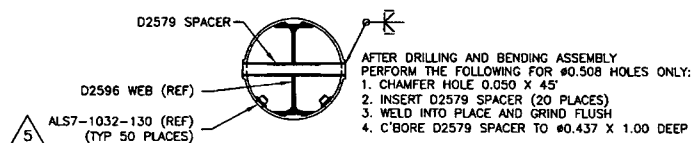
DETAIL B
SCALE 5:24



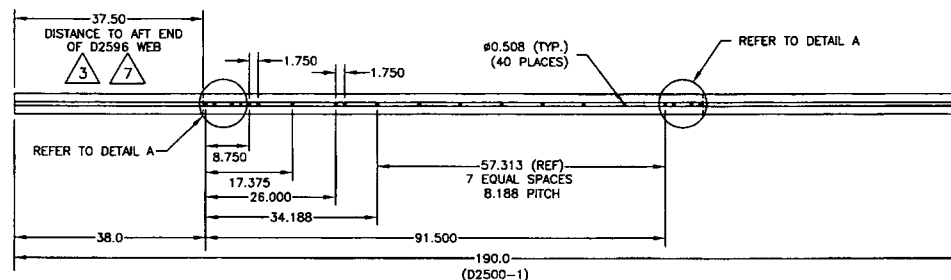
DETAIL C
SCALE 5:24



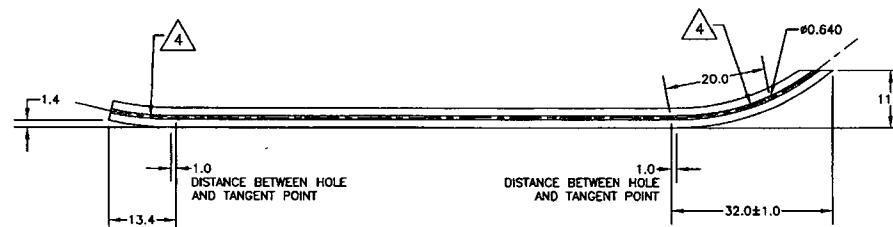
SECTION D-D
SCALE 5:24



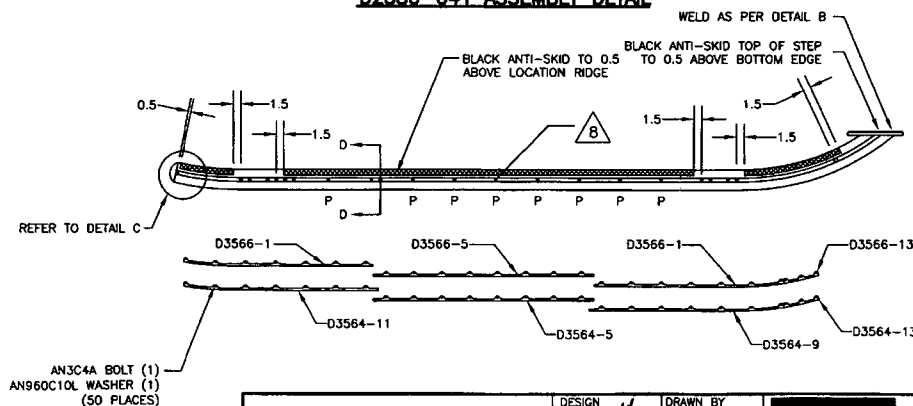
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

COPYRIGHT © 1996 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	07.02.27	D2580	SHEET 2 OF 3
		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

RELEASED
07-06-28

Diagram illustrating the underside of the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a circular component with various assembly points labeled:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX--241/-291
- AN3-SA BOLT (1)
- AN960JD10L WASHER (1) (2 PLACES)
- SEE NOTE ii)
- D2855 CAP
- 0.40

D2579 SPACER

D2596 WEB (REF)

AL57-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

△
C

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

#0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0

91.500

190.0
(D2500-1)

[illegible]

FORWARD VESSEL ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN

DRAWN BY

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

PH
CHECKED <i>[Signature]</i>
DATE 07.02.27

APPROVED *RH*

DRAWING NO.
D2580

RE
SHEET 3 OF

TITLE	205 SKIDTUBE ASSEMBLY
-------	-----------------------

REV. 0
SHEET 3 OF 3
SCALE
1:24

DART

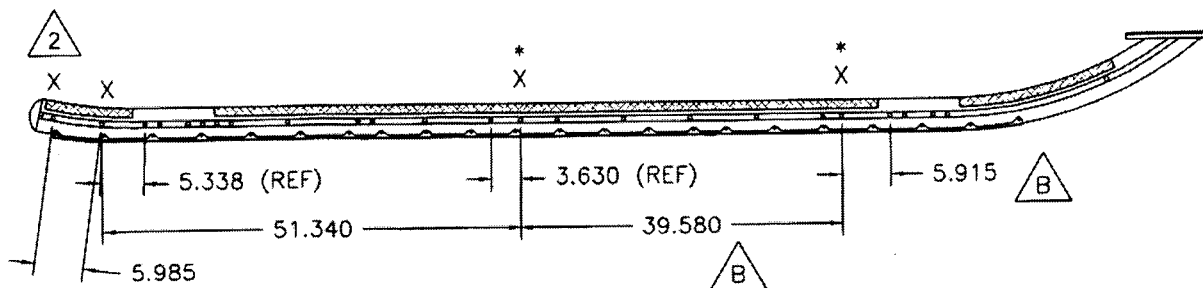
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DEO 9183	REV. "B" SHEET 1 OF 1
DATE 00.05.15		TITLE ADD SKIDTUBE P/N D2580-045	SCALE NTS
A	00.03.29	NEW ISSUE	
B	00.05.15	39.580 WAS 39.620	

DART ENGINEERING ORDER

AMEND DRAWING D2580-041 C TO ADD D2580-045 ASSEMBLY

D2580-045 IS IDENTICAL TO D2580-041, EXCEPT FOR THE FOLLOWING CHANGES:

- 1) INSTALL CROSS BOLT SPACERS AT LOCATIONS MARKED 'X' ACCORDING TO THE FOLLOWING PROCEDURE.
 - a) DRILL $\varnothing 0.508$ HOLES AT LOCATIONS SHOWN BELOW MARKED 'X'. CHAMFER HOLES $0.030 \times 45^\circ$. NOTE THAT HOLES WILL ALSO HAVE TO BE TRANSFERRED TO THE D2596 WEB AT THE * LOCATIONS. IT IS ACCEPTABLE TO PRE-DRILL THE D2596 WEB IN THESE LOCATIONS BEFORE INSTALLING THE WEB IN THE SKIDTUBE. OPEN HOLES TO $\varnothing 0.63$ AND TOUCH UP WITH ALODINE PER QSI 005 4.1.
 - b) INSERT D2579 CROSS BOLT SPACERS INTO THE HOLES.
 - c) WELD INTO PLACE PER DART QSI 004 AND GRIND FLUSH.
 - d) REMOVE SPILL OVER LEAVING HOLE DIMENSION $\varnothing 0.380$ - $\varnothing 0.390$.
- 2) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.
- 3) POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 INSTEAD OF WHITE (REF. 4.3.5.1).



Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NO. 139

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barday E.
Joint Welding Procedure GTAW
Part number and Job number D205 634 041 / B 36286

TEST WELDS REQUIRED

BASE METAL Aluminum
Penetration Complete ☐ Partial ☒
Current AC ☒ DC ☐
WELDING PROCESS TIG
Single Weld ☒ Double Weld ☐
Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skid tube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08-01-07 Qualifier Pat. Dm. A.